Quality Control

<b>Work Order II</b> February-12-14 9:01			*113	225*						Page 1
tem ID: D353	32-1	,	Accept	*N900	<b>040</b>	100	<b>)</b> *		rt *N	
tem Name: Space Start Date: 2/10/ Required Date: 2/10/ Reference:	14 <b>Start Qty:</b> 12.0	1 /		Cust Item Customer:	ID:			Sto	<sup>™</sup> *N	S2*
	cess Plan: MLJ	• •		<del></del>	ate:		F	Run Sta Sto	, 'IV	R1* R2*
equence ID/ Vork Center ID	Operation Description	N (1000)	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3532	Rev A									
00 *1	Hardinge CNC LATH  Memo  1-TURN REV:	HE SMALL  AS PER FOLIO FA643 & DW  A DWG REV: A 2-	0.00 0.00 G D3532 ,FOLIO DEBURR AS REQUIREI	D			_/2_		,	14/02/2
*11	QC2- Inspect parts of	if machine FAI/FAIB	0.00				_/2_			/14/02/27
<sup>120</sup> *1 <i>つ</i> ∩*	QC8- Inspect parts -	second check	0.00				12			SAS TO A SO
QC	Memo		0.00					,		

DQA:			_ Date:											$^{\prime\prime}$ aa $^{\prime\prime}$
			D-4-			WORK ORDER NON	-C(	ONFO	RMANCE / U				_	AEROSPACE
QA Closed:			Date:			T				v	Vork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube	<b>7</b> .	Water Jet		Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Therr	noforming	Finishing	Rec/Sto	e/Packaging		Other
NCR I	۷o.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	1	Initial	Act		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	<u> </u>	QC Inspector
Design														
Doc/Data														
Equip/Tooling			i											
Handling/Pre									·					
Material	$\vdash$		ł											
Operator Offset/Setup	$\vdash$		ŀ											
Process	$\vdash$													
Supplier														
Training							1						-	
Transport														
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng (	Gear				General				_		<del></del>		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ાં [		Temperature/Cure
		1	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	\	Weld
		Cuffs			· <u> </u> _	Contamination			tions Incomplete/l	Jnclear	Part Moved		\	Wrong Stock Pulled
		Crushing				Countersink		-	ned/off center	L	Positioned V			
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	$\vdash$	Mislab		L	Power Loss/	Surge	(	Other
		inspectio	•	Tube	<u> </u>	Drawing	L	Misrea						
		Marks/Cl			<u> </u>	Drill Holes	_	Off-set						
}	$\vdash$	4	Sequence		<u> </u>	Finish	L	-1	Calibration					-
		Wave/Tw	vist in Tub	e		Fit/Function	1	Out of	Sequence					

Work Order ID 113225 \*113225\* Page 2 February-12-14 9:01:28 AM Item ID: D3532-1 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Spacer **Start Qty: 12.00** \*19\* **Start Date:** 2/10/14 **Cust Item ID:** Required Date: 2/10/14 **Reg'd Oty:** 12.00 \*19\* **Customer:** Reference: Run Start Process Plan: \_\_\_\_\_ Date: **Tooling: Approvals:** Date: Stop Date: SPC (Y/N): OC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Qty** Oty Stamp **Run Hours** Code Number Identify as per dwg & Stock Location: 51054 130 0.00 \*130\* 14-02-28 Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 #111-03-3 140303 \*140\* QC 0.00 Memo Quality Control

DQA:		D	ate: _						•						TRAGG
QA Closed:		D	ate:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP	PDATE	Wo	ork Order up	odate only	—	AEROSPACE
						DISPOSITION				AGAINST	•	PARTMENT	• 1		
Work Orde	er:											· · · · · · · · · · · · · · · · · · ·			
Part N	No					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		1	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	No				!	Suspected Unapproved			Large Fab	Composite			Supplier		
Root		ĺ			Descr	ription of work order update		nitial	Acti	on		Sign &		_	
Cause	Da	te S	tep	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	า	QC Inspector
Design															
Doc/Data			į												
Equip/Tooling			ı												
Handling/Pre															
Material		:													
Operator															
Offset/Setup	Ш										,				
Process		- 1													
Supplier		İ												İ	
Training			l												
Transport															
Unapproved															
							FAI	ULT CAT	TEGORY						
Landi	ng Gear					General		_				_	_		
	Bend	ing				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced
	Cent	re Not Co	oncen	tric		BOM/Route		Grain				Over/Under	tolerance		Set-up
	Cracl	cs				Broken/Damage/Defect		Hardwa	re			Part Incorred	:i		Temperature/Cure
	Crim	p/Kink/R	Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing		Weld
	Cuffs					Contamination		Instruct	ions Incomplete/U	nclear		Part Moved			Wrong Stock Pulled
	Crusi	ning				Countersink		Misalig	ned/off center			Positioned V	/rong		
	Heat	Treat				Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
	Inspe	ction St	rip in	Tube		Drawing		Misread	d .						
	Marl	s/Chatte	er			Drill Holes		Off-set							
	Turn	ing Sequ	ence			Finish		Out of 0	Calibration						
	Wav	e/Twist i	n Tub	e		Fit/Function		Out of	Sequence						

**Picklist Print** 

February-12-14 9:01:31 AM

Work Order ID: 113225

\*113225\*

Parent Item:

D3532-1

\*D3532-1\*

Parent Item Name: Spacer

**Start Date: 2/10/14** 

Required Date: 2/10/14

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP Rev:A New Issue 06-07-12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No	-		_	f	89.1667		0.36			
*MDFI BII	NR0 750	)*							**				

\*MI)+I HINH() /5()\*

Delrin Round Bar 0.75"

Location Loc Code Loc Qty MAT039 89.1667 89.1667

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE	W	ork Order up	odate only	$\neg$	AEROSPACE
Q/ Closed.			Dute.				_								
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
	•					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging	_	Other
NCR N	Ю.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root			:		Desci	ription of work order update		Initial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification		QC Inspector
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre	_														
Material															
Operator															
Offset/Setup															
Process															
Supplier		:													
Training															
Transport			T.											1	
Unapproved				<u> </u>	<u> </u>		<u></u>	=				· ·			
							FA	ULI CA	regory						
Landi		1				General		1		•		٠		一.	15
		Bending			$\vdash$	Bend BOM/Rayta	-	4	Program		┝	Outside Dim	<b>⊢</b>	_	Pressure/Forced
		Centre No	or concer	atric	$\vdash$	BOM/Route	⊢	Grain			_	Over/Under	<b>⊢</b>	_	Set-up
	$\vdash$	Cracks Crimp/Kin	k/Dinnlo	Maya	-	Broken/Damage/Defect Burrs	-	Hardwa	ire ion Incomplete/Und	aualifiad		Part Incorred Part Lost/Mi	<b>⊢</b>		Temperature/Cure Weld
		Cuffs	ik/kibbie	y wave	-	Contamination	-	-{ `	•	•		1	- SSILIB	_	
	-	Crushing			-	Countersink	$\vdash$	-1	tions Incomplete/Ui gned/off center	ncledi	_	Part Moved Positioned V	Vrong L		Wrong Stock Pulled
i	$\overline{}$	Heat Trea	ıt		-	Cut Too Short	<u> </u>	Mislabe			$\vdash$	Positioned v		$\neg$	Other
		Inspection		Tuhe	-	Drawing		Misread			Щ	I ower ross)	Juige [		Julei
	-	Marks/Ch		Tube		Drill Holes	<u> </u>	Off-set							f
	$\vdash$	Turning S			-	Finish	$\vdash$		Calibration						·
	$\vdash$	Wave/Tw				Fit/Function	_	4	Sequence						
L	ı					,	1	1							

DART AEROSPACE LTD	Work Order:	113225
Description: Spacer	Part Number:	D3532-1
Inspection Dwg: D3532 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

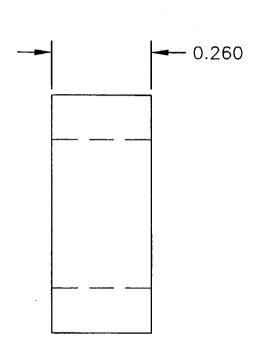
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0 625			MJP-04	Ven
Ø0.391	+0.006/-0.001	0.392			2 1 4	1.1.1
0.260	+/-0.010	0,625	/		/ ) 1	( ) 5
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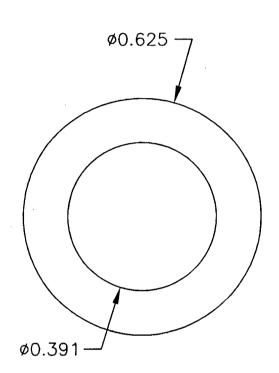
			V <sub>1</sub> O		
Measured by:	Mosp	Audited by:	40 9-89	Prototype Approval:	N/A
Date:	14/02/27	Date:	14/02/27	Date:	N/A

Rev	Date	Change	Revised by,	Approved
Α	07.10.09	New Issue	KJ/EC/DD	R



	DESIG	n PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		INC.
1	CHECK	(ED M	APPROVED	DRAWING NO.			REV. A
l		#	<i>-   </i>	D3532		SH	EET 1 OF 1
	DATE			TITLE			SCALE
	06.0	6.26		SPACER			4:1
	Α		06.06.26	NEW ISSU	JE	·	





## D3532-1 SPACER

## D3532-1 SPACER

1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)

2) FINISH: NONE

- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES



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